

Date: Tuesday, 31/03/2009 1:04:38 PM  
 User: Julie Dawson

# Process Sheet

**Customer** : CU-DAR001 Dart Helicopters Services  
**Job Number** : 46743  
**Estimate Number** : 11144  
**P.O. Number** :  
**This Issue** : 31/03/2009 **S.O. No.** :  
**Prsht Rev.** : NC  
**First Issue** : / / **Type** : MACHINED PARTS  
**Previous Run** : 43620  
**Written By** :  
**Checked & Approved By** : JUD 09.03.31  
**Comment** : Est A 04.06.09 New issue KJ/RF

**Drawing Name** : BRACKET  
**Part Number** : D32075  
**Drawing Number** : D3207 REV A  
**Project Number** : N/A  
**Drawing Revision** : A  
**Material** :  
**Due Date** : 07/04/2009 **Qty:** 6 **Um:** Each

## Additional Product

Job Number:



**Seq. #:** **Machine Or Operation:** **Description :**

1.0 M6061T6S125 6061-T6 .125 Sheet



**Comment:** Qty.: 0.0773 sf(s)/Unit Total : 0.4637 sf(s)  
 6061-T6 .125 Sheet  
 Material: 6061-T6 (QQ-A-250/11) 0.125" thick  
 (M6061T6S.125)  
 Identify for D3207-5  
 Batch: 110062 HB 9-4-1

2.0 WATER JET FLOW WATER JET



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3207  
 Dwg Rev: A  
 Prog Rev: A

HB 9-4-1

9

2-Deburr if necessary

1

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-4-1

4.0 QC8 SECOND CHECK



**Comment:** SECOND CHECK

S 07/04/01 (XS)

5.0 BRAKE NC NC BRAKE



**Comment:** NC BRAKE  
 Form as per Dwg D3207

S 07/04/02

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 46743

Part Number: D32075

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/02 (x9)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09-04-2

(9)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3

11/09/04

START TIME:

11:15

OVEN TEMPERATURE:

320

FINISH TIME:

11:45

BR 09-04-2 (9)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

09-04-02

(x9)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 245

88 09/04/05 (x9)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/06

Job Completion



MF 09-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

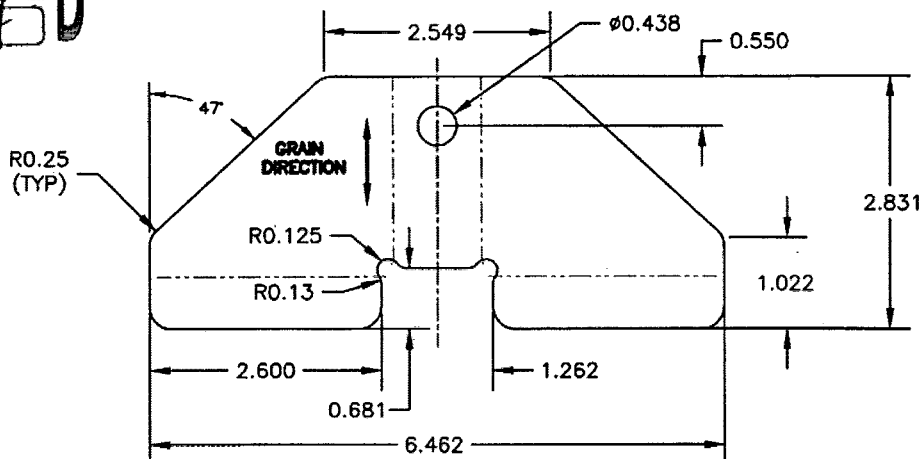
**NOTE:** Date & initial all entries



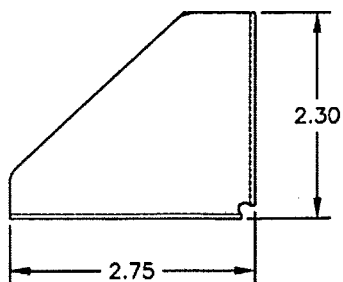
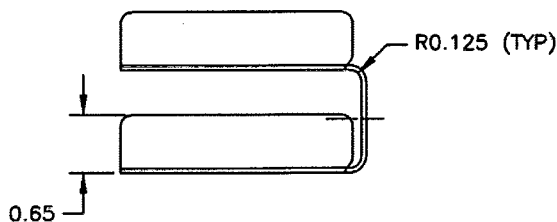


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DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

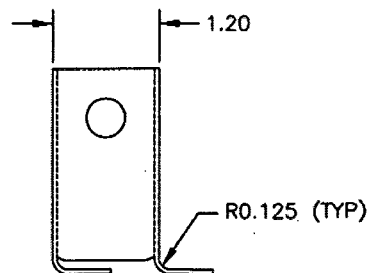
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**D3207-1/-2 FLAT PATTERN**



**D3207-1 BEND DETAIL (SHOWN)  
D3207-2 OPPOSITE**



**D3107-1/-2 BRACKET**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (M2024T3S.050)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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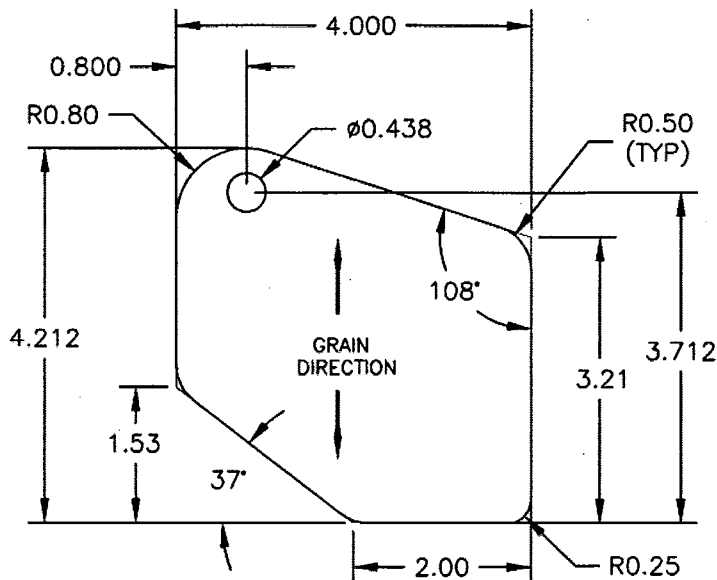
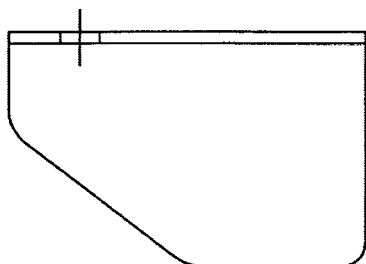
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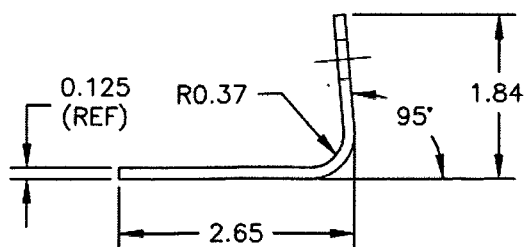
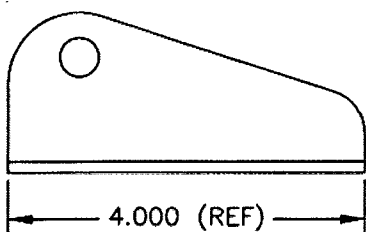


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04.04.05



**D3207-3 FLAT PATTERN**



**D3207-3 BEND DETAIL**

**D3207-3 BRACKET**

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

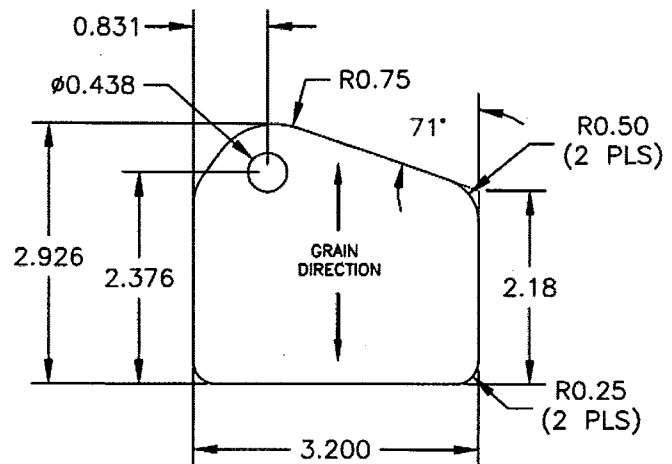
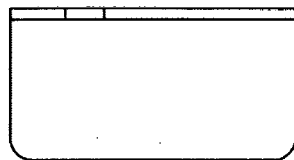
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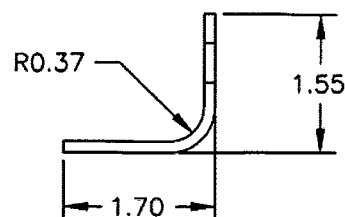
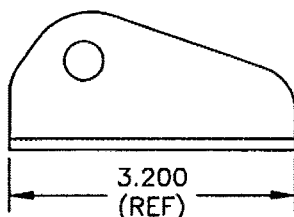


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**D3207-5 FLAT PATTERN**



**D3207-5 BEND DETAIL**

**D3207-5 BRACKET**

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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